

Fig.1

Fig.2

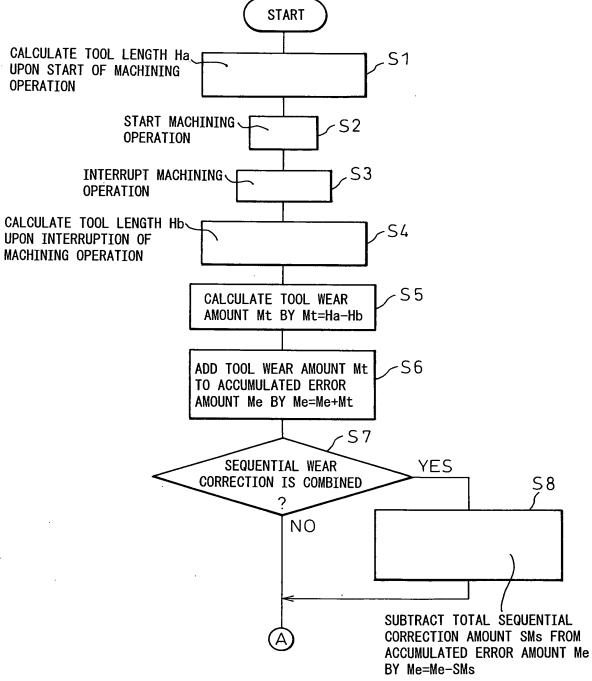


Fig.3 REPLACE WORKING~ **S9** T00L CALCULATE TOOL LENGTH Ha. -S10 UPON RESTART OF MACHINING **OPERATION** RESTART MACHINING **OPERATION** S12 CONTINUE MACHINING **OPERATION WHILE** CORRECTING POSITIONAL COMMAND FOR SPINDLE INTERRUPT MACHINING S13 OR TABLE BY ACCUMULATED **OPERATION** ERROR AMOUNT Me CALCULATE TOOL LENGTH Hb. S14 UPON INTERRUPTION OF MACHINING OPERATION CALCULATE TOOL -S15 WEAR AMOUNT Mt BY Mt=Hb-Ha - S16 ADD TOOL WEAR AMOUNT Mt TO ACCUMULATED ERROR AMOUNT Me BY Me=Me+Mt S17 SEQUENTIAL WEAR CORRECTION IS COMBINED YES S19 SUBTRACT TOTAL SEQUENTIAL NO CORRECTION AMOUNT SMs FROM ACCUMULATED ERROR AMOUNT Me BY Me=Me-SMs S18 YES MACHINING OPERATION NO IS CONTINUED? **END**

Fig.4 **START** -S21 READ WEAR COEFFICIENT Mk -S22 MONITOR CUTTING LENGTH CL CALCULATE SEQUENTIAL WEAR CORRECTION AMOUNT Ms BASED ON Mk AND CL S23 CALCULATE TOTAL SEQUENTIAL CORRECTION SMs AND TOTAL -524 **CUTTING LENGTH SCL** BY SMs=SMs+Ms AND SCL=SCL+CL S25 CORRECT POSITIONAL COMMAND FOR SPINDLE OR TABLE BY SMs -S26 START MACHINING-**OPERATION** S27 MACHINING OPERATION-YES IS CONTINUED? NO S28 READ TOOL WEAR AMOUNT Mt -S29 RENEW WEAR COEFFICIENT Mk BY Mk=Mt/SCL **END**

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Fig.5